

Date: Tuesday, 9/4/2007 11:30:25 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL TUBE
Job Number	: 34420		
Estimate Number	: 12312		
P.O. Number	: N/A	Part Number	: D34735
This Issue	: 9/4/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3473 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 28807	Drawing Revision	: B
		Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 10/4/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	6 Um: Each
Comment	: Est Rev: A New Issue 06-03-02 JLM Est Rev: B As per Rev B 06-05-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.1616 sf(s)/Unit Total: 0.9696 sf(s)

304/316 0.018 SHEET

Batch: M105 490

SAD 07/09/04

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3473

Dwg Rev: BProg Rev: B

SAD 07/09/04 E

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/09/04

6

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

SAD 07/09/05 (6) counter

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur if necessary.

2-Roll & Bead as per Dwg D3473

3-Spot weld as per Dwg D3473

SAD 07-10-16 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:30:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUBE

Job Number: 34420

Part Number: D34735

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/10/16 (6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/16 (6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/10/16 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/10/17 (6)

Job Completion



U 07/10/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

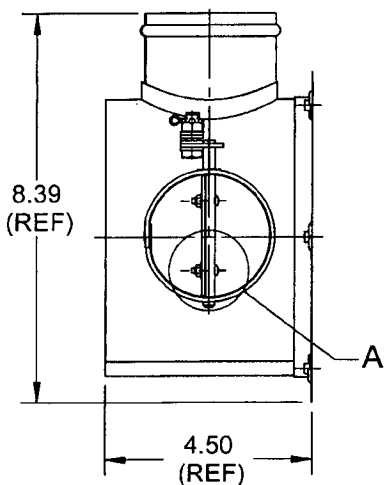
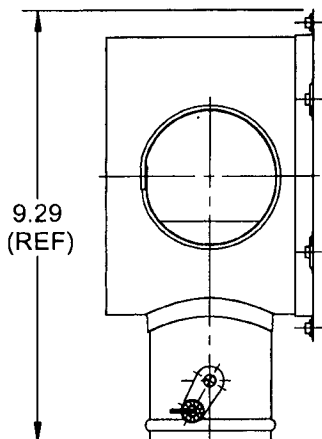
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

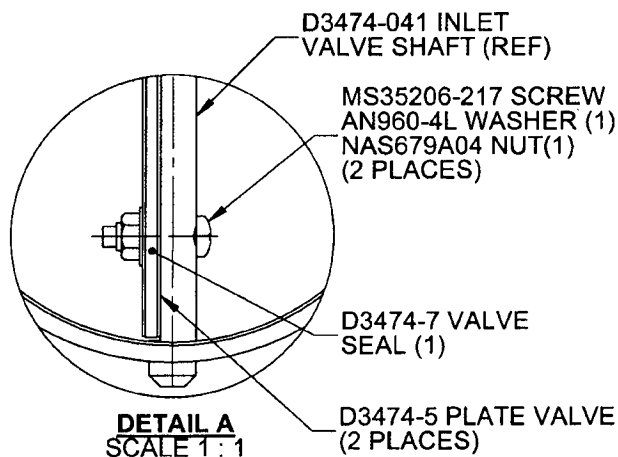
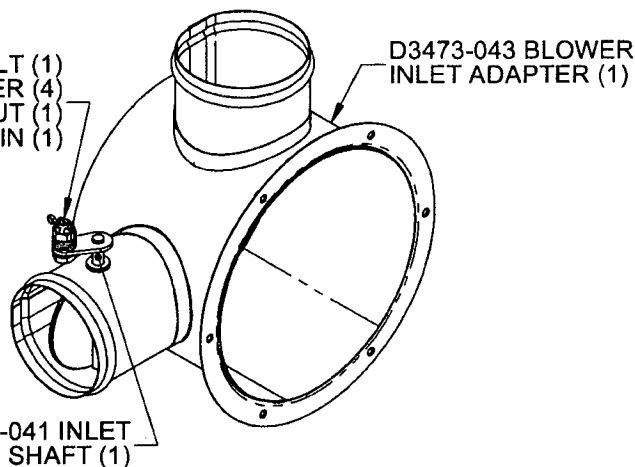


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CHECKED H	APPROVED H	DRAWING NO. D3473	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4
A	06.02.07	NEW ISSUE	
B	06.05.16	D3473-5F/-7F: 9.750 & 8.810 WERE 9.60 & 8.60	

RELEASED
06-05-16 H



D3470-9 BOLT (1)
AN960-416 WASHER (4)
AN310-4 NUT (1)
MS24665-153 COTTER PIN (1)



D3473-041 BLOWER INLET ADAPTER

NOTES:

- 1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

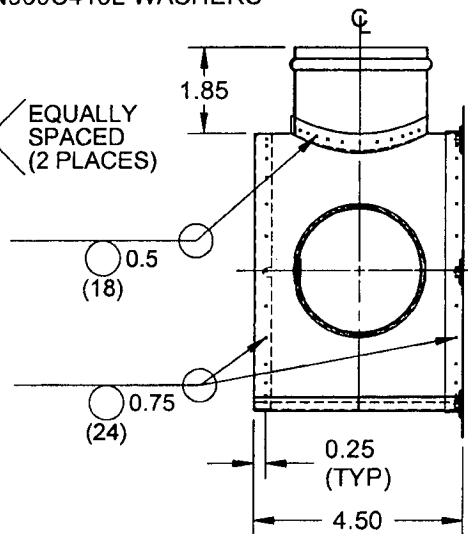
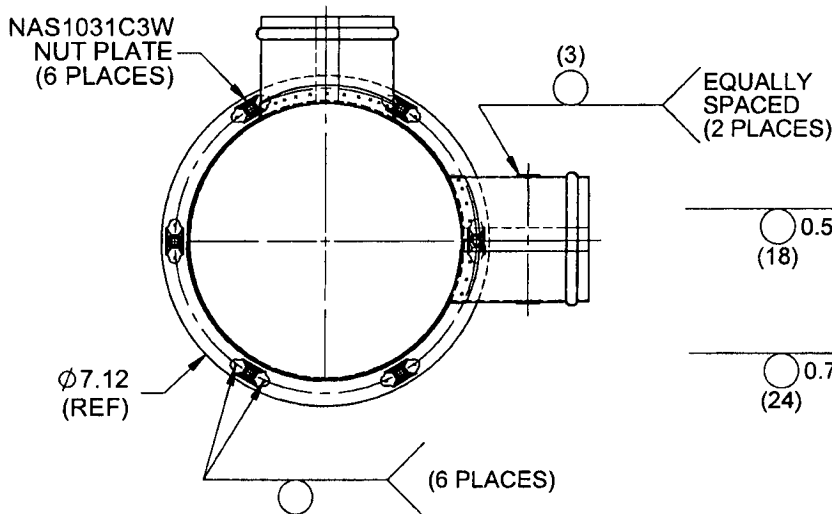
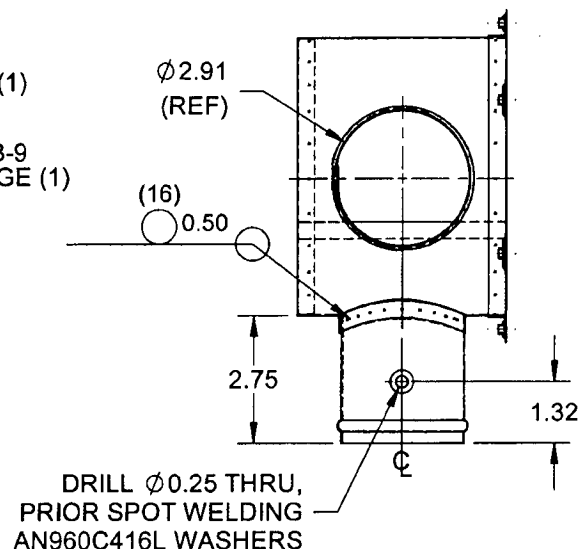
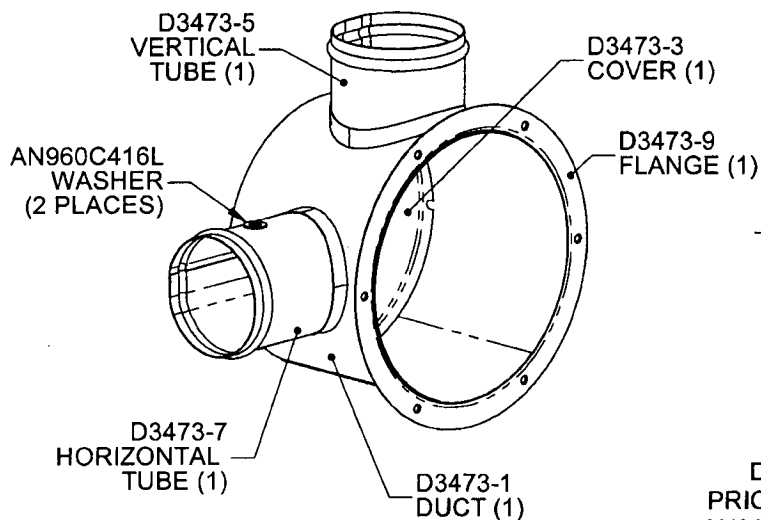
QTY -041	P/N	DESCRIPTION
X	D3473-041	BLOWER INLET ADAPTER
1	D3470-9	BOLT
1	D3471-043	BLOWER INLET WELDMENT
1	D3474-041	INLET VALVE SHAFT
2	D3474-5	BUTTERFLY VALVE
1	D3474-7	BUTTERFLY VALVE SEAL
1	AN310-4	NUT
2	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
2	MS35206-217	SCREW
2	NAS679-A04	NUT

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CHECKED H	APPROVED H	DRAWING NO. D3473	REV. B SHEET 2 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	
			SCALE 1:4

RELEASED
06.05.16**D3473-043 BLOWER INLET WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

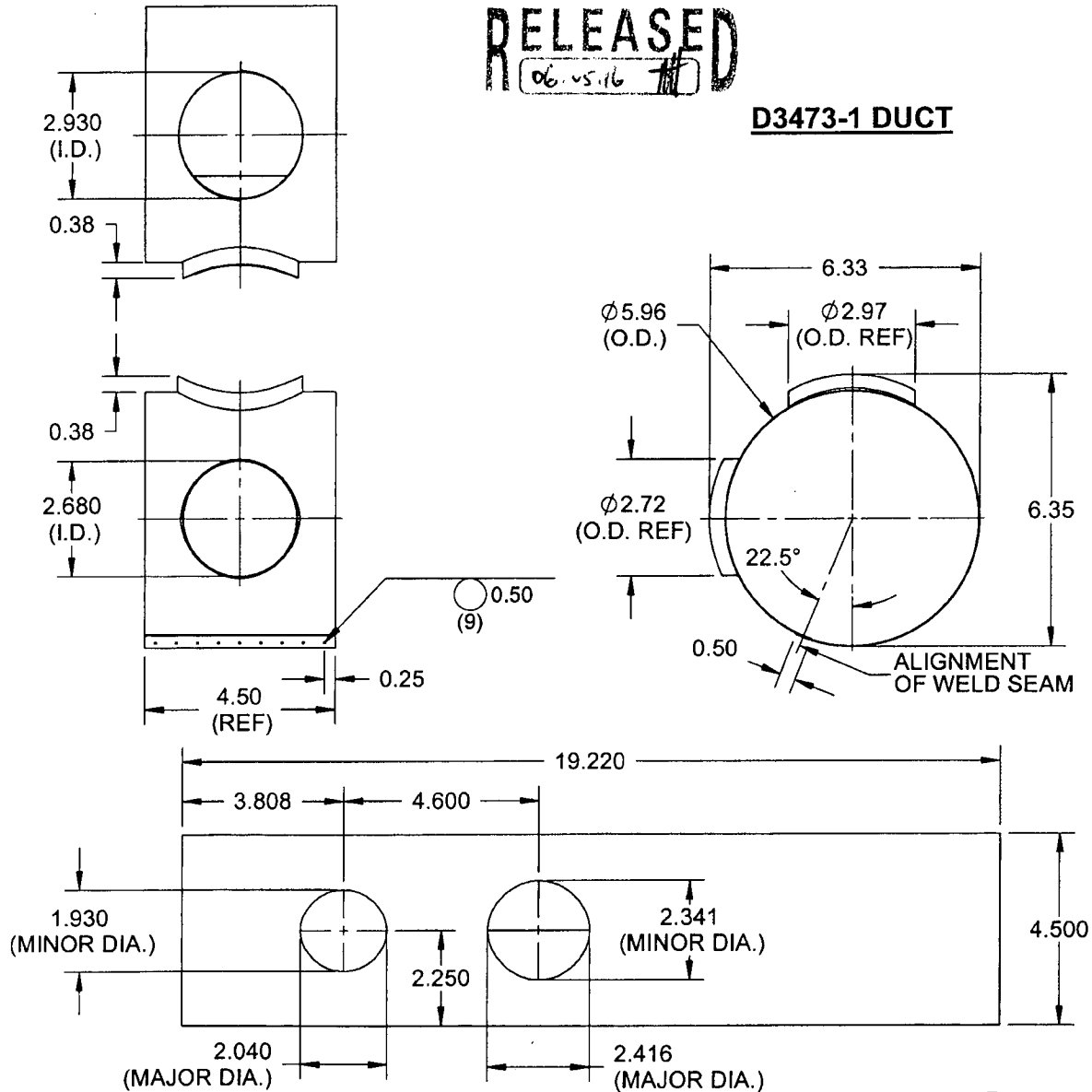
QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

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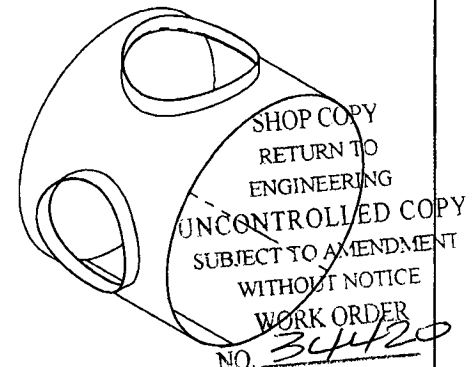
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3473	REV. B SHEET 3 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4

RELEASED
*[Stamp: 06.05.16]***D3473-1 DUCT****D3473-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010



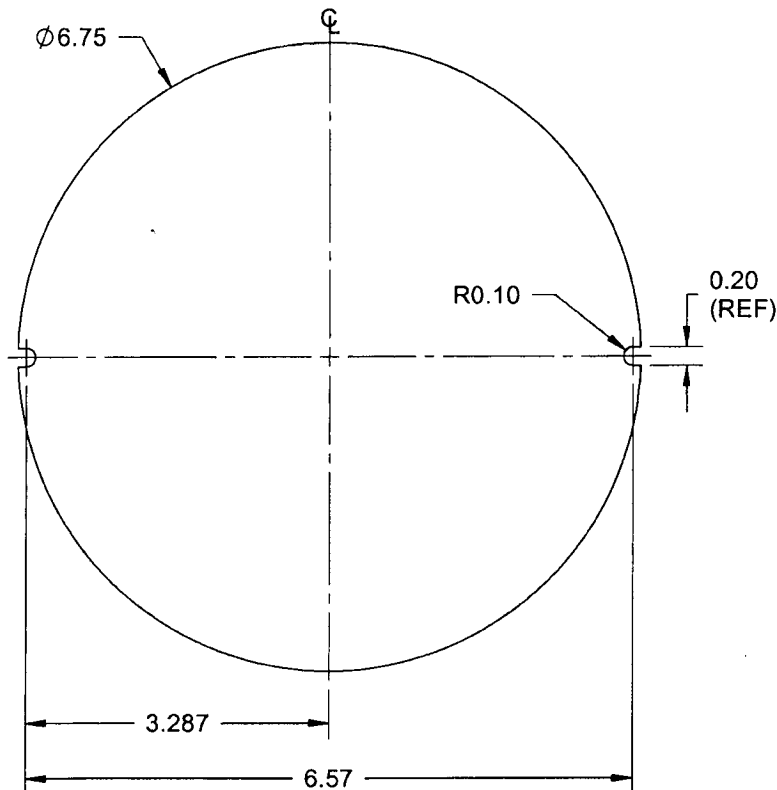
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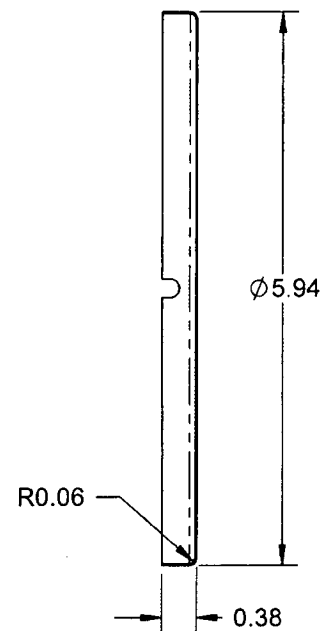


DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
06-05-16 H



D3473-3F COVER FLAT PATTERN



D3473-3 COVER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

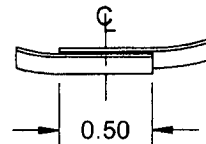
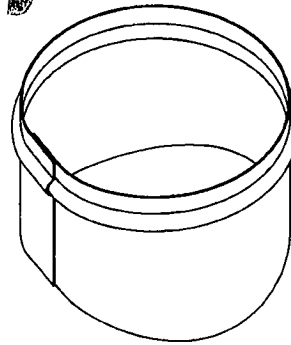
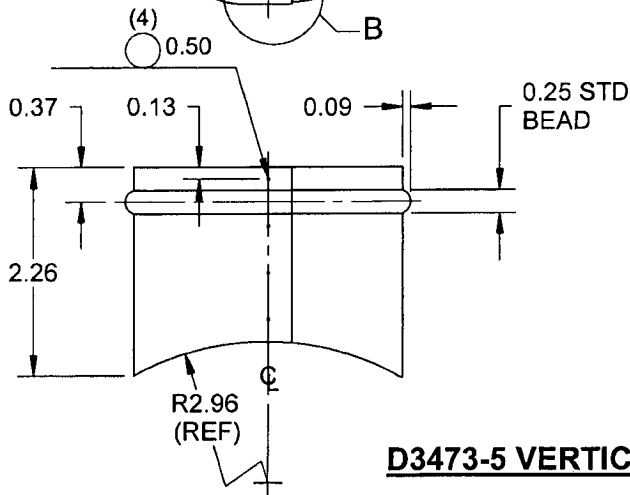
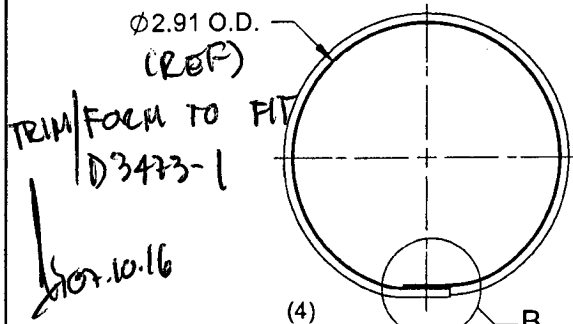
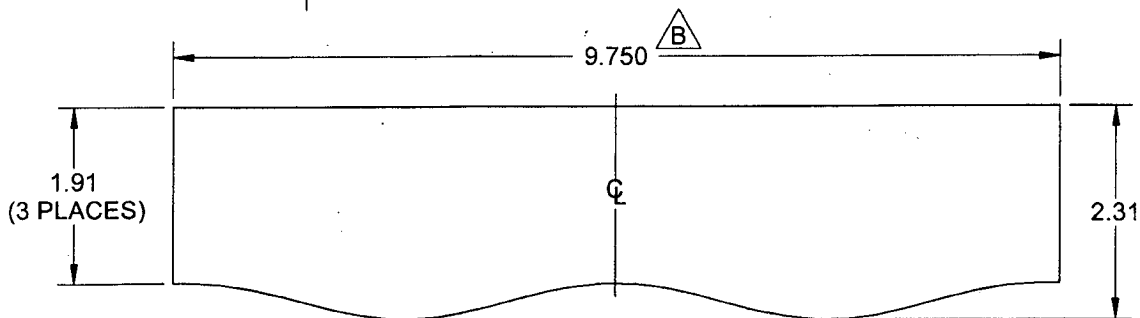
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
06.05.16**DETAIL B**
SCALE 1:1**D3473-5 VERTICAL TUBE****D3473-5F VERTICAL TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

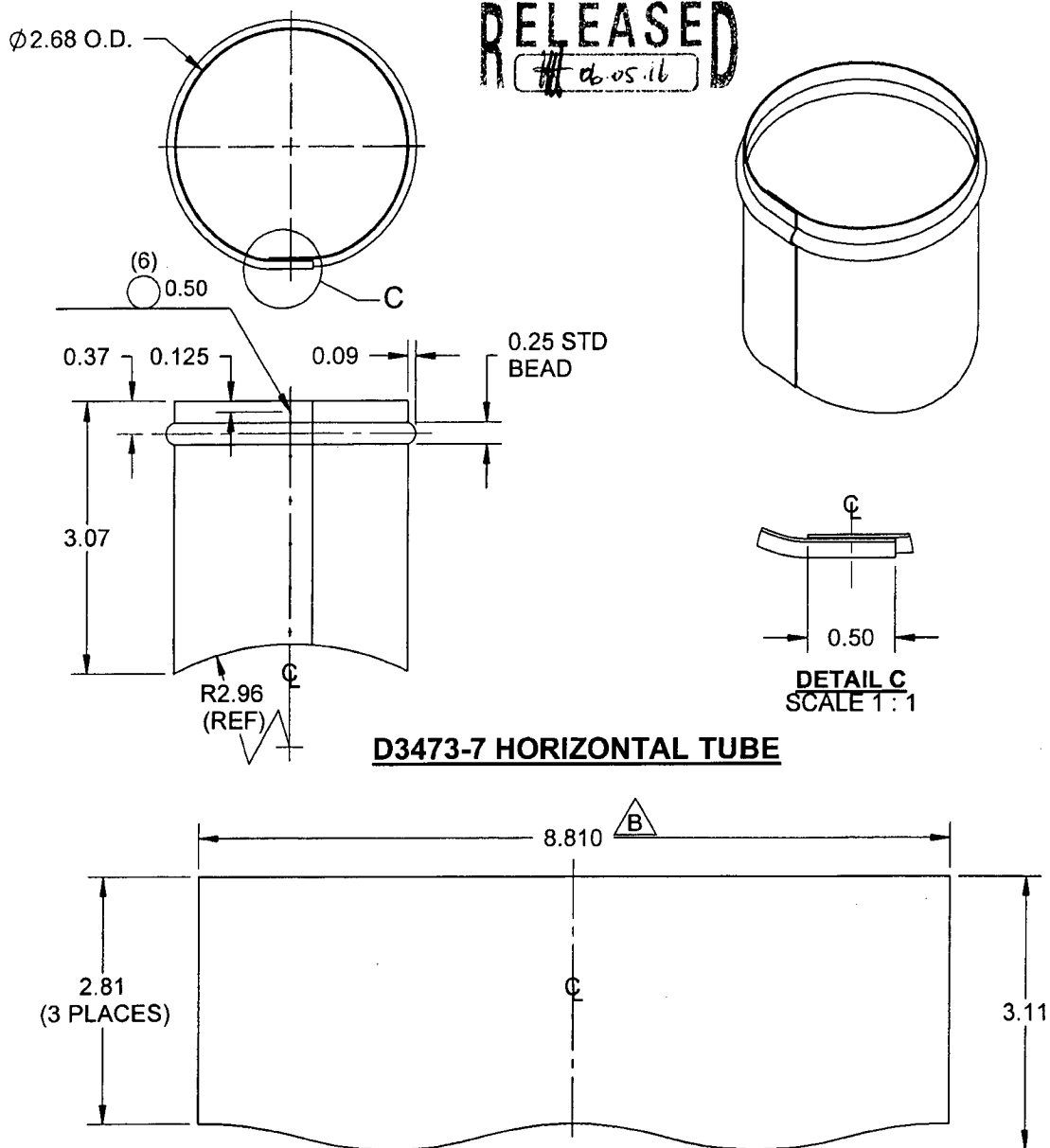
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3473	REV. B SHEET 6 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2



D3473-7 HORIZONTAL TUBE

D3473-7F HORIZONTAL TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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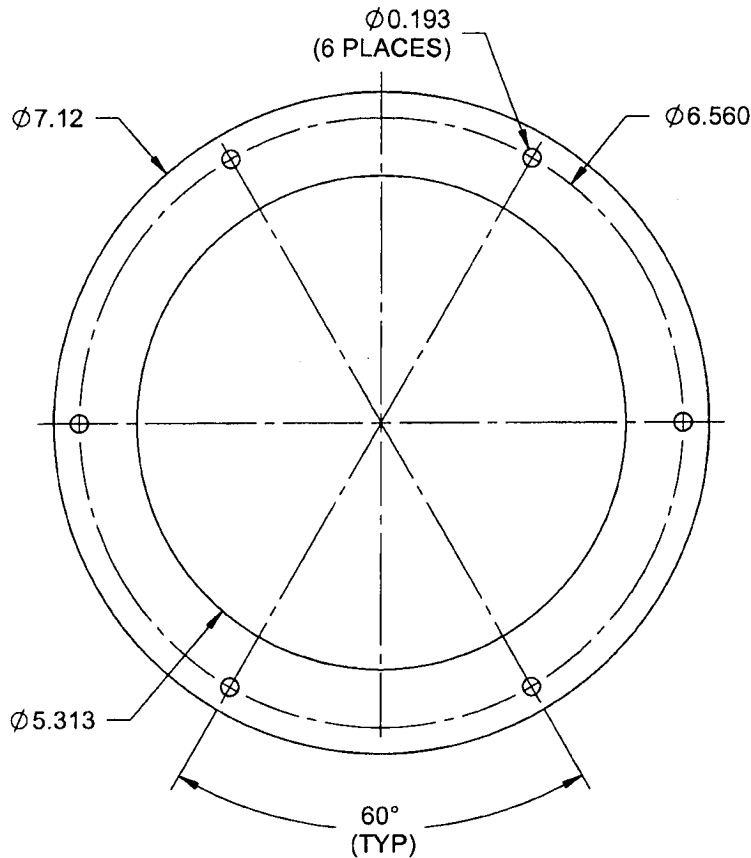
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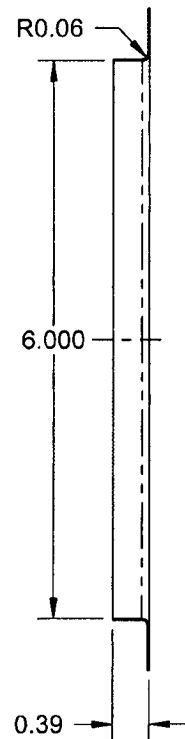


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CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3473	REV. B SHEET 7 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER SCALE 1:2	

RELEASED
06.05.16



D3473-9F FLANGE FLAT PATTERN



**D3473-9 FLANGE
BENDING DETAIL**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 23

EMPLOYEE: Melanie Fautoux

PART NUMBER: D3473-5

JOB NUMBER: B 34420

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.078

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	[<u>/</u>]	[]
PENETRATION:	[<u>/</u>]	[]
PULL STRENGTH:	[]	[] PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/01/16

QUALIFIER: SB